

Work Order ID 117642

April-29-14 2:59:56 PM

Ship 30/04 to Harvey

117642

PRELIMINARY ISSUE

Page 1

Item ID: D4967-1

Accept

N9000040100

Setup Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Bracket

Start Date: 4/29/14

Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/30/14

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4967

part A 9.89 15.07.09

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: AL
Prog Rev: PAS
2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

27

9-89

14/4/30

(4)

mm/14/04/30

(4)

mm/14/04/30

4

Inspect as per
Dwg PAS

Work Order ID 117642

April-29-14 2:59:56 PM

117642

Page 2

Item ID: D4967-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Bracket
Start Date: 4/29/14 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 4/30/14 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		DAS 30 9-89		4			4/29/30
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			Inspect as per New PDS
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo	0.00 0.00		DAS 9 9-89					N/A

Work Order ID 117642

April-29-14 2:59:56 PM

117642

Page 3

Item ID: D4967-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/29/14 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 4/30/14 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: Harvey 0.00

Memo

0.00

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

DAS

9

9-89

① 15-07-24

ROSS452

KS for MLS 15/7/13

u 14.04.30

POSITIVE RECALL

EFFECTIVE 140429

RELEASED 15-07-09

DAS

9

9-89

Released
 at Lew A

Picklist Print

April-29-14 2:59:55 PM

Page 1

Work Order ID: 117642

117642

Parent Item: D4967-1

D4967-1

Parent Item Name: Bracket

Start Date: 4/29/14

Required Date: 4/30/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 14.02.10 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

sf

628.7100

M304S18GA

304/316 .050 Sheet

**

1

4-15-7-13

Location

Loc Qty

Loc Code

MAT019

616.71

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

39.75

M128254

108.71

M128435

187.25

M128864

224

MAT020

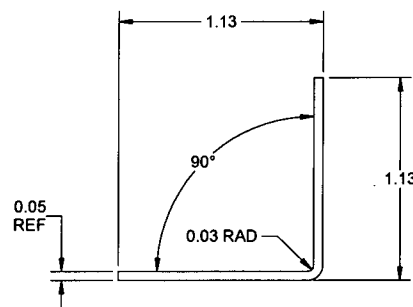
12

124029

2

M126098

10



D4967-1 BRACKET

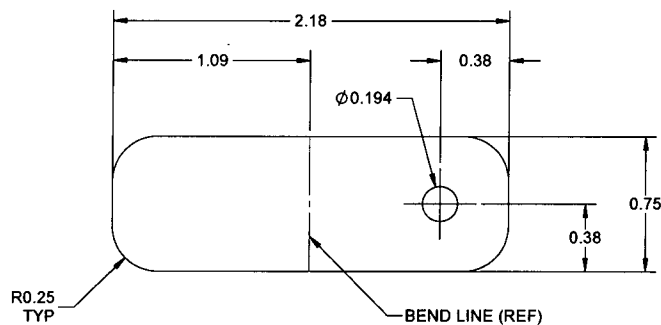
no 107642

NOTES:

- 1) MATERIAL: MADE FROM D4967-1F
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

UNAPPROVED

A	NEW ISSUE	AK	13.10.30
REV	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED		DRAWING NO.	REV. A6
MFG. APPR.		D4967	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	13.10.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4967-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

UNAPPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A6
MFG. APPR.		D4967	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	13.10.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DAR
AEROSPACE

Work Order: 117642

Part Number: D4967-1

[illegible]

Engineering Approval (if necessary)

Date _____

Receiving Report

Date: 11/4/28

Batch No: 11/28254

Supplier: COMI

Dart P/O: 20968

Packing Slip: Yes ☒ No ☒
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒
 New Supplier Yes ☐ No ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☒ N/A ☐
 QC18 Inspection ☒ 9-11-02-20 N/A ☐
 Work Order Q.R.C. N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Rec'd	Quantity Short	Quantity Inspected	Quantity Rejected	Comment / NCR Number
	1141R PO-1141R		30				

Initials of Receiver

QC12

Production/Admin:

Date

Received/Costing

Initial

Location

References

All amounts are calculated in domestic currency.

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-CAM002	Campi Steel								
PO22968	6		M6063TSC.75X.75W f .125		2/24/2014	2/18/2014	21.0000	\$0.49	0.0000	0	\$10.37
CAD	No		6063 CHANNEL.750 X.750 X.125w m128254	f	20.0000	DESJ02		\$10.37	0.0000	0	
	7		M304S11GA sf		2/19/2014	2/18/2014	192.0000	\$11.40	0.0000	0	\$2,189.20
	No		304/316 0.125 Sheet sf m128254	sf	192.0000	DESJ02		\$2,189.20	0.0000	0	
	8		M304S18GA sf		2/19/2014	2/18/2014	352.0000	\$4.62	0.0000	0	\$1,624.83
	No		304/316 .050 Sheet sf m128254	sf	352.0000	DESJ02		\$1,624.83	0.0000	0	
Total Received Quantity:											565.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$3,824.41
Total Balance Due Quantity:											0.0000

METALLURGICAL TEST REPORT

Certificate: 910378 1
Customer: 007035 510

Date: 1/20/2014 Page: 1

Steel: 304

Finish: 2B

Your Order: 744781

NAS Order: PN 0034356 11

Corrosion: ASTM A262/10 A, 180 Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED, UNS 30400
ASTM A240/13a, A480/13, A666/10, ASME SA240/13, SA480/11a, SA666/13
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/11, SA479/11
AMS 5511J XMRK; MIL-S-5059D AMEND3 (X CROWN MEAS)
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; Q98766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1, RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
01K9D9 B	01K9D9 B		.0460	48.0000	21,200	COIL	9	1	74261496

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
K9D9	US	.0559	18.1875	.4025	1.7780	.2865	.0743	8.0535	.0300	.0075
SI %										
.1915										

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
01K9D9 B	01K9D9 B	F T	101.78	53.45	48.49	88.00	88.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ERIC HESS

1/20/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO22968**

Purchase Order Date 2/11/2014

PO Print Date 2/12/2014

Page Number 3 of 8

Order From :

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

VC-CAM002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA -- (Free Carrier)

6	M6063T5C.75X.75W.125	6063 CHANNEL.750 X.750 X.125w	3/21/2014	20.00		\$0.55	\$11.00
			Yes				
			3/21/2014				

AS PER QUOTE 337114

Line Total: \$11.00

7	M304S11GA	304/316 0.125 Sheet	3/18/2014	192.00		\$12.70	\$2,438.40
			Yes				
			3/18/2014				

MATERIAL: AISI 304/316 SS SHEET ANNEALED
AS PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240

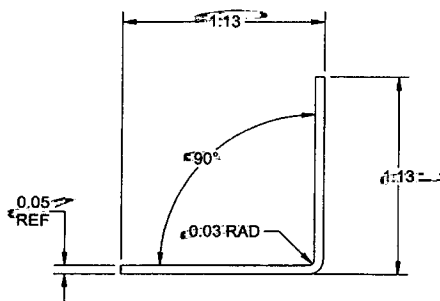
Line Total: \$2,438.40

8	M304S18GA	304/316 .050 Sheet	3/18/2014	352.00		\$5.14	\$1,809.70
			Yes				
			3/18/2014				

MATERIAL: AISI 304/316 SS SHEET ANNEALED
AS PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240

PO Instructions: Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart



D4967-1 BRACKET

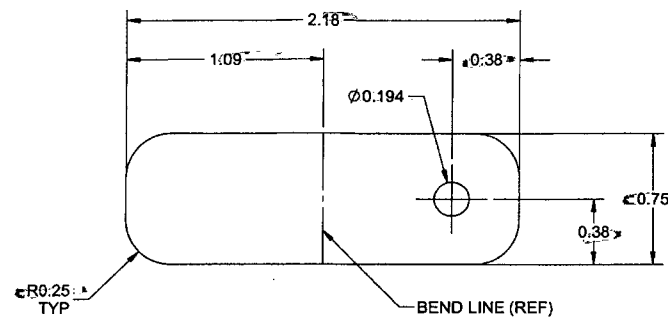
NOTES:

- 1) MATERIAL: MADE FROM D4967-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2014-07-02

A	NEW ISSUE	AK	13.10.30
REV	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4967	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	13.10.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D4967-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
(REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4967	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	13.10.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-07-02